Winchester Super X2 Semi-automatic Shotgun Owner's Manual

Important instructions for

Winchester Super X2 Semi-automatic Shotgun

U.S. Repeating Arms Company, Inc.
344 Winchester Ave.
New Haven, CT, U. S. A. 06511-1970

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Use the space below to record information about your new Super X2 shotgun.

Model _____

Serial Number _____

Purchased From _____

Date of Purchase _____

We sincerely hope that you are pleased with your new Winchester Super X2 shotgun. We at U.S. Repeating Arms Company thank you for the privilege of providing this shotgun to you. We are especially proud of the many years of enjoyment it is certain to provide for you and your family. The Super X2 is another shotgun in an over 130 year-old tradition of producing quality firearms for the World's sportsmen. Quality of manufacture, design, craftsmanship and function are of utmost concern to us. We believe you'll find that your new Super X2 meets the Winchester tradition of quality in every way. If you have any questions or comments regarding your new firearm, please feel free write to us at our administrative offices:

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WINCHESTER SUPER X2 SHOTGUNS

PRINTED IN U.S.A. MF9811/98062

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The Super X2 is truly a remarkable new shotgun — a world class shotgun with world class origins. Its manufacture represents an unprecedented collaborative effort between the traditional Winchester firearms manufacturing plant in New Haven, Connecticut and our associated plants in various European locations. Thus the distinctive barrel marking. In addition, Super X2 testing and research and development spans the globe from our Utah facility to Connecticut to Belgium. It is a new breed of Winchester from a new "global" Winchester brand.

Every aspect of its design points toward two primary objectives: (1) unmatched reliability, and (2) superb handling. While it is true that the overall design draws on nearly a century of Winchester firearms shotgun experience, it is clear that this in an all new Winchester with performance features the most demanding hunters and shooters want.

A few things to take notice of are:

- The remarkably simple , self-adjusting, self-cleaning gas piston system.
- The alloy receiver that balances weight between the hands with just enough barrel weight for smoothness.
- The acclaimed Invector® Plus choke system that incorporates long choke tapers and a back-bored barrel for better patterns.
- The large, exceptionally functional safety button.

As you learn about your new Super X2 and begin shooting it, we're sure you'll agree its design sets new standards for reliability and handling performance.

GUN SAFETY WARNINGS

IT IS ESSENTIAL THAT THESE OPERATING INSTRUCTIONS BE THOROUGHLY STUDIED BEFORE USING THIS FIREARM TO ASSURE PROPER AND SAFE GUN HANDLING. FAILURE TO FOLLOW THESE INSTRUCTIONS OR FAILURE TO OBEY ANY SAFETY WARNING MAY RESULT IN INJURY TO YOURSELF OR OTHERS, OR CAUSE DAMAGE TO YOUR GUN.

As a gun owner, you accept a set of demanding responsibilities. How seriously you take these responsibilities can be the difference between life and death. There is no excuse for careless or abusive handling of any firearm. At all times handle your Super X2 and any other firearm with intense respect for its power and potential danger.

PLEASE READ AND UNDERSTAND ALL OF THE CAUTIONS, PROPER HANDLING PROCEDURES AND INSTRUCTIONS OUTLINED IN THIS BOOKLET BEFORE USING YOUR NEW FIREARM.

1. Do not carry a loaded gun with a live round in the chamber while walking, running, climbing a tree, crossing a fence or anywhere you might slip or fall, drop the gun or otherwise bump or jar the gun. A gun that is dropped, bumped, or jarred with a chambered round might accidentally discharge even with the safety on, causing serious injury to you or someone else. When a round is chambered keep the safety on until you are ready to shoot.

2. Do not rely on the safety to prevent accidental discharge. Many safeties merely block the trigger and prevent firing by pulling the trigger. The safety may not prevent an accidental discharge due to dropping, jarring, or bumping a gun.

3. Use only ammunition for which the gun is chambered as indicated on the barrel, to prevent excessive pressure and possible serious personal injury.

4. Incorrectly reloaded ammunition can cause serious personal injury and damage to the firearm due to excessive pressure. Reload only after proper instruction and in strict compliance with instruction and data contained in current reloading manuals.

5. Never point a gun at anything you do not intend to shoot. Always keep it pointed in a safe direction in case of accidental discharge.

6. Always check to ensure that the barrel is free of obstructions before loading and using the gun. If you experience light recoil or off sound, check the barrel for an obstruction.

7. Before firing, clean any grease or oil out of barrel with cleaning rod and patch. Grease or heavy accumulation of

oil can cause excessive pressure and result in serious personal injury.

8. Keep barrel, chamber and action free of rust. Rust in the barrel and chamber can cause excessive pressures resulting in serious injury. A rusted, pitted or eroded barrel should be replaced.

9. Use hearing protection to prevent ear damage from repeated exposure to gunfire.

10. Always use proper shooting glasses to prevent eye injury from flying particles.

11. Never carry a loaded gun in a motor vehicle or carry one into a dwelling. Always carefully unload the gun before entering a motor vehicle, a dwelling or an area such as a camp. Always point a gun in a safe direction while loading or unloading to prevent serious injury in case of an accidental discharge. Never load in the house or in your vehicle.

12. Never shoot at a hard, flat surface or at the surface of water to avoid a ricochet and possible serious personal injury to yourself or a bystander.

13. Store gun in a clean dry place out of reach of children and separated from stored ammunition.

14. Never alter any parts of your gun. Any alterations or adjustments that may become necessary to the operating mechanism should be performed by a qualified gunsmith.

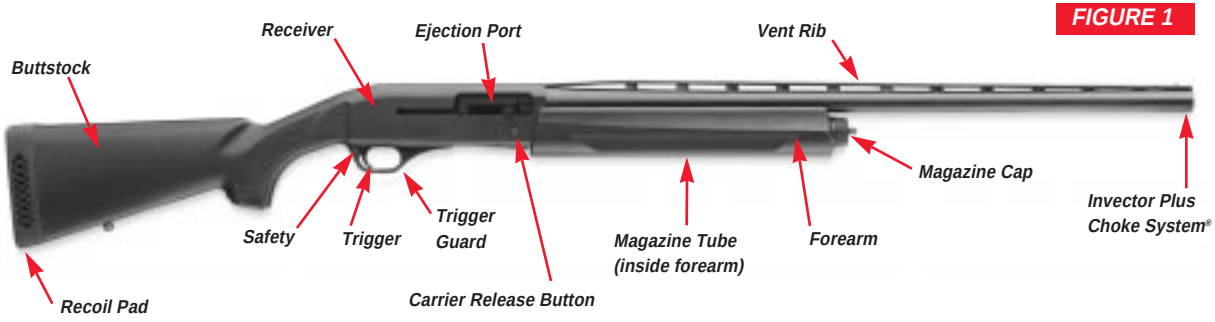
15. Hunting from elevated surfaces such as tree stands is dangerous. Doing so may increase the risk of handling any firearm. Always make certain that the stand being used is safe, sturdy and stable. Always make certain your firearm is unloaded when it is being taken up and down from the stand. Always make certain that your firearm is not dropped from the stand or dropped while it is being taken up or down from the stand.

16. Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.

General Description/Operation

Your new Super X2 is one of several different versions and configurations offered. The basic operating procedures are the same for all of them. Where there are differences they are pointed out in this manual for your convenience.

The Super X2 is a semiautomatic design that allows the shooter to shoot followup shots by merely pulling the trigger, firing the first shot, and then letting the gas piston system automatically move a shell from the magazine to the chamber where it is fired with a pull of the trigger.



This can be repeated until the magazine is empty. A single round can also be inserted into the chamber manually or moved from a loaded magazine by cycling the action with the bolt handle.

It is capable of shooing five shots (with the magazine plug removed, using 2 3/4" loads) in rapid succession with each pull of the trigger.

The short stroke of the gas piston along with the snug, gas sealing fit of the piston rings and tight fit of the piston rod, limits the amount of combustion gases blown past the gas cylinder and into the receiver, keeping the inside of the receiver clean.

This is an exceptionally advanced design that offers reliable function of the gas system and easy disassembly for maintenance and cleaning. However, in order to keep your new shotgun in top condition and operating at its peak performance you must read, understand and follow all of the instructions in this manual.

Prior to using live ammunition, familiarize yourself thoroughly with these operating instructions. Get accustomed to the feel of your new gun. Know the forces required to operate the action. Learn how to pull the trigger, and above all, know the location and operation of the safety. Procedures for disassembly and operation of various components are outlined in the sections below. Please read and study them thoroughly. In addition, always remember:

USE THE CORRECT AMMUNITION AS REFERENCED BY THE INSCRIPTION ON THE BARREL.

BEFORE LOADING YOUR GUN BE SURE ALL GREASE AND OIL HAVE BEEN REMOVED FROM THE BARREL AND CHAMBER, AND THERE ARE NO OBSTRUCTIONS.

IMPORTANT: ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

Terminology and Descriptions

Descriptions in this manual generally refer to the gun in the horizontal position. That is, in the normal firing position. For example, the muzzle is forward or front; the butt stock is rearward or rear; the trigger is downward or underneath; the sight is upward or on top. For general parts terminology, refer to Figure 1.

The Winchester Super X2 is also shown disassembled to the extent necessary in order to follow instructions contained in this book (refer to Figure 14 later in this manual). Figure 2 covers the general features and benefits of the Super X2 design.

Throughout this manual the "action" refers to the mechanism of this shotgun which loads and secures the shell in the chamber.

Serial Number

The serial number is located on the left side of the receiver, just above the trigger guard. Record the serial number at the front of this manual for future reference.

Ammunition

There are several different versions of the Super X2. They are inscribed as follows on the receiver:

•**Magnum 3 1/2".** This model is designed to shoot all factory field loads including 2 3/4" length field loads, 3" Magnum loads and 3 1/2" Magnum loads. It has a 3 1/2" chamber. (It is not designed to shoot the lightest factory target 7/8 oz. and 1 oz. loads.)

• **Magnum 3".** This model is designed to shoot all factory loads from 2 3/4" target loads to 3" Magnums. This model has a 3" chamber. It is specifically configured to be able to handle down to 7/8 oz. factory ultra-light target loads. (It is NOT designed to shoot 3 1/2" shells.)

Winchester ammunition is always an excellent choice for your new Winchester firearm, delivering the unmatched performance and dependability you want.

(Continued on page 10)

Super X2 Features

Not only does the advanced alloy receiver offer the strength of steel, it also affords the Super X2 exceptional between-the-hands balance, with just the ideal barrel weighting for a smooth swing.

The entire bolt assembly removes easily for a thorough cleaning. This is a gun designed for hard work under real hunting conditions.

You get a complete selection of functional stock materials to choose from: composite black, dipped camouflage composite and walnut models.

The large safety button offers excellent convenience with both gloved and ungloved fingers. Plus, it is reversible for left-handed shooters.

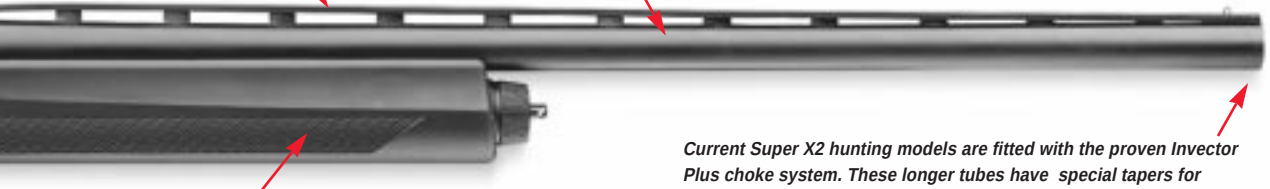
The trigger assembly easily removes with a durable two-pin system. No tools are necessary and it takes just seconds to do maintenance and cleaning.

Deluxe recoil pad for maximum comfort.

FIGURE 2

Super X2 field guns feature our fully floating ventilated rib.

The barrel is back-bored for improved pattern performance.



Current Super X2 hunting models are fitted with the proven Invector Plus choke system. These longer tubes have special tapers for optimum patterning — plus they are specially designed for back-bored barrels. It allows you to change choke constrictions to meet the demands of the game being hunted or target shot. Extra-full choke tubes are available for hunting turkey or other game requiring extremely tight patterns with lead shot loads.

The advanced, self-cleaning gas system uses just the amount of gas needed to cycle the action. Even the 3 1/2" Magnum model can function reliably down to 2 3/4" field loads. The 3" Magnum version handles all loads from 3" Magnum down to the lightest 7/8 oz. target loads.

Invector® Plus threaded choke system.

MAKE SURE YOU USE ONLY THE EXACT AMMUNITION/CALIBER AS LISTED ON THE LEFT SIDE OF THE BARREL.

U.S. REPEATING ARMS COMPANY, INC., CAN ASSUME NO RESPONSIBILITY FOR INCIDENTS WHICH OCCUR THROUGH THE USE OF CARTRIDGES OF NONSTANDARD DIMENSION OR THOSE THAT WHEN SHOT, DEVELOP PRESSURES IN EXCESS OF INDUSTRY STANDARDS ESTABLISHED BY THE SPORTING ARMS AND AMMUNITION MANUFACTURERS' INSTITUTE (SAAMI).

DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS, OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS THOROUGHLY AFTER EXPOSURE.

Incorrectly reloaded ammunition can cause serious personal injury and damage to the firearm due to excessive pressure. Reload only after proper instruction and in strict compliance with instructions and data contained in current reloading manuals.

MAGAZINE CAPACITY

It is extremely important that you know the magazine capacity of your Super X2. It is listed on the hang tag supplied with your Super X2. Under appropriate circumstances — at a range or other suitable shooting location — load your magazine to full capacity and make note of the number of shells. Remember, "total capacity" includes an additional round which can be loaded manually in the chamber in addition to a full magazine. Total capacity is generally (magazine, plus chamber) as follows:

3 1/2" Magnum Versions

3" and 3 1/2" Magnum loads: Three in magazine, one in chamber.

2 3/4" loads: Four in magazine, one in chamber.

3" Magnum Versions

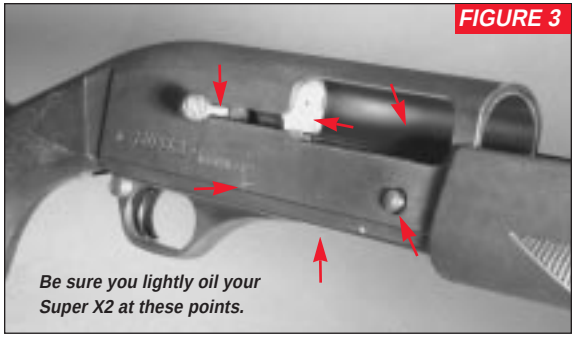
3" Magnum Loads: Three in magazine, one in chamber.

2 3/4" loads: Four in magazine, one in chamber.

With magazine adapter (plug) installed

Two shells in the magazine, one in chamber.

IMPORTANT: The Super X2 will handle mixed loads of different shell lengths, which will affect total capacity.



Initial Cleaning / Oiling

Some metal parts of your new Super X2 have been coated at the factory with a rust preventative compound. Before using your Super X2, clean the anti-rust compound from the inside of the barrel, receiver, breech bolt mechanism and the action/chamber areas. A high quality, lightweight gun oil should be used to remove this compound and to give your new gun its first lubrication. Clean the barrel using a cleaning rod and patch as explained under "Cleaning and Maintenance Suggestions" found later in this manual.

If your new Super X2 is to be stored for an extended period of time, it is permissible to leave the rust preventative compound in place and keep your Super X2 in its box for maximum protection during long-term storage.

Before beginning assembly of your Super X2 you should first wipe the mechanism clean and apply a few drops of quality oil on the surfaces shown (see Figure 3).

Avoid applying too much oil. Only a light film is necessary. Excessive oil should be wiped off, especially in cold weather.

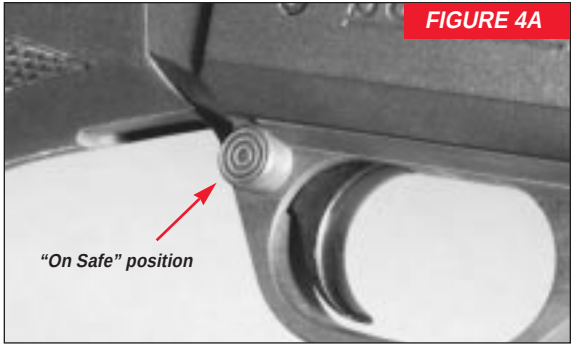
Operation of the Safety

Your new Super X2 shotgun is designed with a cross bolt type safety. It is located just rearward of the trigger on the trigger guard: convenient for gloved or ungloved fingers. It is essential that you become very familiar with the feel, look and operation of the safety on this shotgun before attempting to load and shoot.

With the safety in the "on safe" position the trigger and hammer are blocked and the shotgun cannot be fired. In the "off safe" position — if your gun is loaded with a round in the chamber — the chambered round can be fired by simply pulling the trigger.

The safety on the Super X2 is reversible for right or left-handed operation. It comes from the factory in the right hand position. Verify the installation of your guns' safety. Instructions in this manual are for the safety installed in the right-handed position.

• "ON SAFE". The safety button is pushed fully to the right. The red band on the left side is not showing (see Figure 4A).



• "OFF SAFE". The safety button is pushed fully to the left. A large red band is exposed on the button as it protrudes on the left side. The red band is an added aid to safe gun handling. However, with time and exposure to the elements it can wear off.

Never rely totally on your gun's safety button. It is merely an aid to safe gun handling. Like any mechanical device the safety can possibly fail: it can be jarred or inadvertently manipulated into an unsafe condition. Always keep your shotgun pointed in a safe direction.

At all times in the field keep the safety in the "ON SAFE" position and the barrel pointed in a safe direction. It is a good idea never to load your shotgun until you are in the field and shooting is imminent or until you are at your station and it is your turn to shoot when you are shooting at a range. For extra safety, and as a courtesy to others, fully unload and place the action in the open position at all times other than when shooting is immediately imminent.

THE SAFETY IS REVERSIBLE AND CAN BE REVERSED FROM RIGHT-TO LEFT-HANDED BY A COMPETENT GUNSMITH. WHEN INSTALLED, THE LEFT-HANDED SAFETY WILL HAVE THE SAFETY BUTTON'S RED WARNING BAND ON THE RIGHT SIDE OF THE TRIGGER GUARD.

Note: Do no depend on the red color alone to indicate your gun's safety status, as time, exposure to the elements, and the abrasive action of cleaning agents can erase it.

Initial Assembly / Take Down

Remove the barrel assembly and receiver/stock section from the carton. Wipe them clean and lightly oil component parts as explained under "Initial Cleaning/Oiling."

The Super X2 shotgun usually comes (from the factory) with the barrel removed and the forearm still attached to the magazine tube.

It is important to carefully follow the assembly instructions below — especially steps 1, 2 and 3 — to assure the proper assembly of your shotgun.

ALWAYS PLACE THE SAFETY IN THE "ON SAFE" POSITION BEFORE BEGINNING ASSEMBLY PROCEDURES AND CHECK YOUR GUN CAREFULLY TO BE CERTAIN THAT THE CHAMBER, FEED MECHANISM AND MAGAZINE CONTAIN NO SHELLS.

1. Lock the bolt rearward by pulling the operating handle fully to the rear. If it will not pull rearward it usually indicates that the bolt slide link has fallen out of the end of the socket on the return spring plunger while your gun was being shipped. This is not a problem. You will simply need to refer to the section titled "Bolt Disassembly/ Reassembly" later in this manual for special instructions on how to perform this very easy alignment procedure.

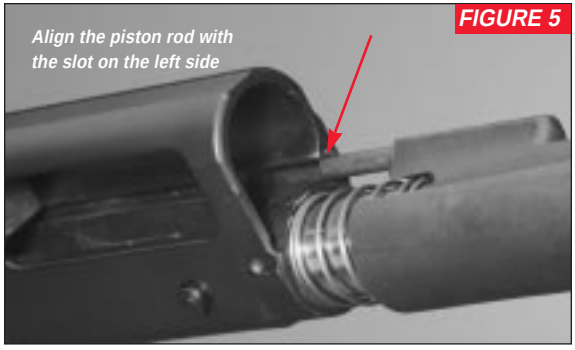
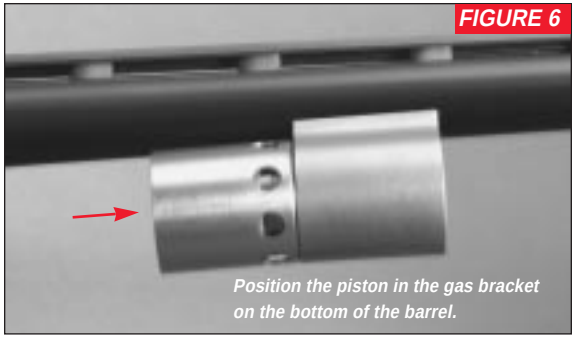


FIGURE 5

2. Carefully remove the forearm from the magazine tube by unscrewing the magazine cap and sliding the forearm forward of the magazine tube.

DO NOT SQUEEZE HARD ON THE OPEN REAR END OF THE FOREARM. TOO MUCH PRESSURE COULD CAUSE THE WOOD TO SPIT.

3. Leave the components of the gas system (the sleeve, sleeve spring and gas piston) in place on the magazine tube. They do not need to be removed, except for cleaning. In the event that components of the gas system have been removed, it is easy to reinstall them as explained below.



4. If the gas piston and sleeve have been removed, first slide the sleeve spring over the magazine tube. Then slide the sleeve onto the magazine tube, piston rod end first. Check the piston rod to make sure it is aligned with the slot on the left side of the receiver (see Figure 5), as viewed from normal shooting position.

5. Take the gas piston in hand and slide it into the rear of the gas bracket on the barrel, smaller end first (see Figure 6).

6. Hold the gun in the vertical position. Slide the gas bracket and gas piston over the magazine tube (see Figure 7). the barrel extension should slip solidly down into the receiver. Make sure the piston rod on the gas sleeve moves freely in its slot in the left side of the

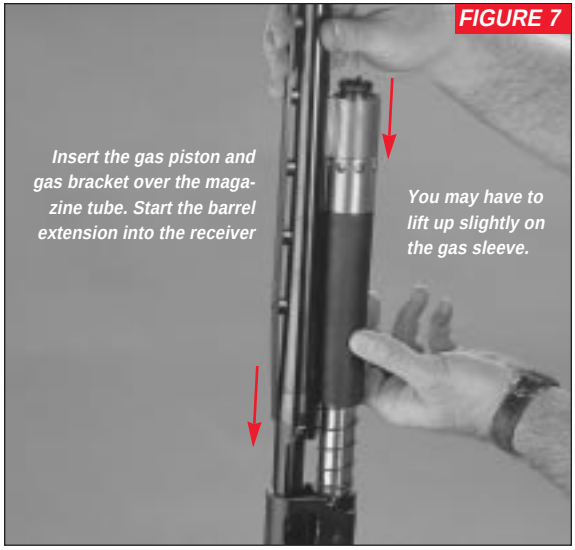


FIGURE 7
Insert the gas piston and gas bracket over the magazine tube. Start the barrel extension into the receiver
You may have to lift up slightly on the gas sleeve.

receiver. On a new gun, with very tight tolerance, it may be necessary to lift up slightly on the gas sleeve to allow the barrel extension the room to drop into the receiver. After you do this always check piston rod alignment as explained previously.

7. Replace the forearm by sliding it onto the magazine tube and over the gas bracket so it seats securely. Install

the magazine cap. Make sure the magazine cap is fully tightened down. Open and close the action several times and retighten the magazine cap. This will ensure a proper seal.

TAKING DOWN THE BARREL —

BEFORE STARTING DISASSEMBLY PROCEDURES, VISUALLY INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO BE ABSOLUTELY CERTAIN THE SHOTGUN IS COMPLETELY UNLOADED. POINT THE BARREL IN A SAFE DIRECTION. PLACE THE SAFETY IN THE "ON SAFE" POSITION'

The red warning band on the safety must not be visible.

Take-down for storage is essentially the reverse of assembly procedures. The action should be left open if disassembly of the rest of the gun will not be performed. If you intend to fully disassemble your gun, you may start with the action closed.

1. Unscrew the magazine cap and remove it.

2. Remove the forearm by sliding it forward off the magazine tube.

3. If you are disassembling for cleaning remove the barrel, piston, piston sleeve and sleeve spring by sliding them forward off the magazine tube. See "Cleaning and Maintenance Suggestions" later in this manual for cleaning procedures.

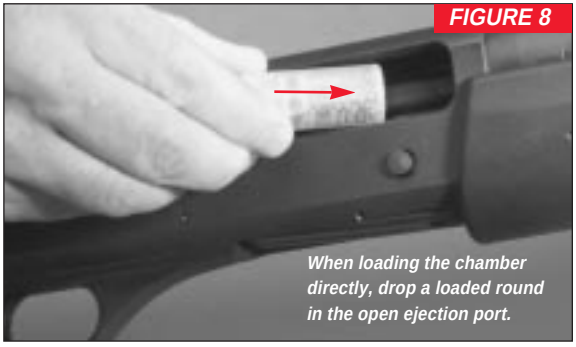
NOTE: If you are disassembling for storage, lock the action rearward. Leave the piston, piston sleeve and spring on the magazine tube as explained previously. Reinstall if they were removed. Install the forearm over the magazine tube and screw on the magazine cap. You will then have two compact units: (1) the barrel, and (2) the action with forearm and stock.

CAUTION: AFTER THE BARREL HAS BEEN REMOVED FROM YOUR GUN, AND YOU INTEND TO STORE YOUR GUN, LEAVE THE BOLT IN THE OPEN POSITION. DO NOT PRESS THE CARRIER RELEASE BUTTON.

If the bolt is release forward with the barrel removed, the bolt handle will hit the front of the ejection port and cause damage to both the receiver and the bolt handle.

LOADING PROCEDURES

Before loading your gun, be sure all grease and oil has been removed from the barrel and chamber and there are no obstructions. Use the correct ammunition referenced by the inscription on the barrel. There are two ways to load the chamber of your Super X2.



Before loading the magazine make sure of the following:

1) Your shotgun is pointed in a safe direction.

2) The safety is in the "on safe" position.

3) You are in an appropriate location for shooting.

4) Shooting will be imminent.

DIRECTLY TO THE CHAMBER, SINGLE SHOT MODE —

1. Place the safety in the "ON SAFE" position.

2. Open the action by pulling back fully on the bolt handle. The bolt will lock in the rearward position. As a matter of practice, always verify that the magazine and chamber contain no shells when the action is opened.

3. A shell can now be placed directly into the ejection port (brass of shell to the rear and crimp to the front). It is fine to push the shell forward into the chamber, or just leave it loose in the port (see Figure 8).

4. Press the carrier release button. This will automatically move a loose round placed in the ejection port, directly into the chamber. Keep your fingers clear of the ejection port whenever closing the action with the carrier release button.

IMPORTANT: The gun is now ready to fire by moving the safety to the "off safe" position and pulling the trigger. After firing with an empty magazine, the bolt will lock rearward, ready for inserting the next shell in the open ejection port.

LOADING THE MAGAZINE —

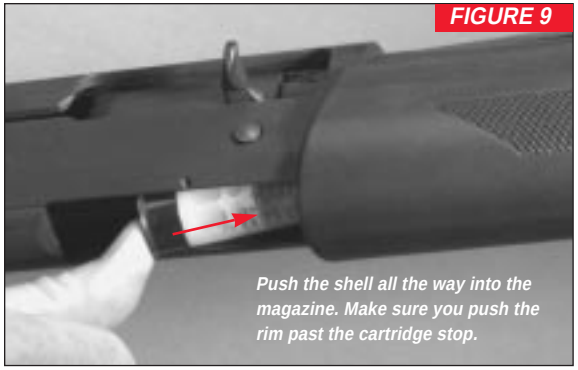
1. Place the safety in the "ON SAFE" position and close the action by pressing the carrier release button.

2. Depress the carrier with the forward end of the nose of the shell.

3. With your thumb on the base of the brass push the shell into the magazine until the shell is held in the magazine by the cartridge stop (see Figure 9). Remove your thumb and allow the carrier to return downward to its original position.

4. Repeat the procedure until the magazine is fully loaded.

5. If firing is imminent, a shell can now be moved from the magazine to the chamber by pulling back fully on the



bolt handle and releasing it forward. A round will be fed automatically from the magazine to the chamber as the bolt closes. Another round can then be inserted into the magazine to load to full capacity.

IMPORTANT: THE GUN IS NOW READY TO FIRE BY MOVING THE SAFETY TO THE "OFF SAFE" POSITION.

DO NOT CARRY A GUN WITH A SHELL IN THE CHAMBER TO AVOID ACCIDENTAL DISCHARGE. IN ALL CASES, WHEN LOADING AND WHEN FIRING IS NO LONGER IMMINENT, MAKE SURE THE SAFETY IS IN THE "ON SAFE" POSITION.

Unloading Procedures

CAUTION: WHENEVER UNLOADING, ALWAYS BE CERTAIN THAT THE MUZZLE IS POINTED IN A SAFE DIRECTION AND THAT THE SAFETY IS IN THE "ON SAFE" POSITION.

ALWAYS INSPECT THE CHAMBER, ACTION, CARRIER AND MAGAZINE VERY CAREFULLY AFTER UNLOADING TO BE SURE ALL LIVE ROUNDS ARE CLEARED FROM THE GUN.

There are two ways to unload your Super X2.

Cycling the action —

POINT THE MUZZLE IN A SAFE DIRECTION. PLACE THE SAFETY THE "ON SAFE" POSITION. MAKE SURE THE ACTION IS CLOSED AND KEEP THE MUZZLE POINTING IN A SAFE DIRECTION. (The red warning band on the safety will not be visible).

1. Grasp the bolt handle and cycle the action until all rounds are transferred from the magazine to the chamber and then ejected. It is possible, with practice, to catch each shell with your free hand as it is ejected. You should always take care to avoid damaging shells. Do not let them fall on hard ground.

2. When the last shell in the magazine has been cycled through the chamber and out the ejection port, the action will lock rearward. The action should lock rearward when the acton is cycled with an empty magazine.

3. Using your index finger, feel the entry of the magazine to make sure there are no longer any shells that have not been fed from the magazine and ejected. Visually inspect the chamber, feed mechanism and magazine to assure there are no shells remaining.

UNLOADING DIRECTLY FROM THE MAGAZINE —

POINT THE MUZZLE IN A SAFE DIRECTION. PLACE THE SAFETY IN THE "ON SAFE" POSITION, MAKE SURE THE ACTION IS CLOSED AND KEEP THE MUZZLE POINTING IN A SAFE DIRECTION.

1. Turn the gun over so the trigger guard is facing up, then push the carrier down with our finger as far as it will go.

2. Push inward on the right side of the cartridge stop, releasing the shell from the magazine. Be careful not to pinch your finger. The cartridge stop is located on the inside right side of the loading port (visually to your left side when looking down into the loading port). When a shell is in the magazine, the stop catches on the brass of the shell. As the cartridge stop is pressed in, the shell will be forced out of the magazine under spring pressure (see

Figure 10). Capture it as it comes out. Press the stop again to release the next shell. Do this until the magazine is empty.

3. With the safety still in the "on safe" position, pull rearward on the bolt handle to eject the cartridge from the chamber. The bolt will lock rearward when the action is cycled with an empty magazine.

4. Using your index finger, feel the entry of the magazine to make sure there are no longer any shells that have not been feed from the magazine and ejected. Visually inspect the chamber, feed mechanism and magazine to assure there are no shells remaining.

IMPORTANT — AFTER UNLOADING ALWAYS VISUALLY CHECK AND KNOW FOR SURE THAT YOUR SHOTGUN IS NOT LOADED.

FIRING PROCEDURES

The semiautomatic or self-loading characteristic of the Super X2 is the obvious primary benefit to the shooter.

For training or target situations your gun can be shot "single shot" by loading one shell at a time through the open ejection port. More commonly you will take advantage of the semiautomatic feature by loading the entire magazine first and then firing repeated shots, if necessary. Both are described earlier under "Loading Procedures."

1. When ready to shoot, and with a loaded shell in the chamber, the safety "on safe", and your finger off the trigger, push the safety to the "off safe" position (with the red warning band fully visible). Your shotgun is now ready to fire with a pull of the trigger

CAUTION: YOUR SHOTGUN IS NOW READY TO FIRE. REMEMBER, THE RECOIL FROM A SHOTGUN, ESPECIALLY MAGNUM LOADS, WILL BE SOMEWHAT HEAVIER THAN MOST OTHER GUNS, SO FIRMLY SHOULDER YOUR SUPER X2, TAKE AIM, AND — WHEN ON TARGET — SQUEEZE THE TRIGGER.

2. As the shell in the chamber is fired, gases from the firing shell are bled off from the barrel at the gas bracket. This forces the gas piston rearward which moves the bolt assembly rearward, ejecting the fired shell.

3. As the bolt returns forward under spring force a shell from the magazine is automatically transferred from the magazine to the chamber and the bolt locks forward. Your gun will now fire again with the pull of the trigger. Immediately put the safety in the "on safe" position (with the red warning ring hidden) until you are ready to fire again.

4. You may fire until the magazine is empty. The bolt will lock rearward after the last shot has been feed from the magazine, fired and ejected. When the bolt locks rearward this usually indicates that both magazine and chamber are empty, and that your shotgun magazine needs to be reloaded. It is important to treat your gun as though it is loaded, even if the action has locked rearward.

At this point either refill the magazine with loaded cartridges (if shooting is going to continue) or fully unload your shotgun (if shooting is completed). Either way, place the safety in the "on safe" position.

WHEN FIRING IS COMPLETED OR WHEN SHOOTING IS NO LONGER IMMINENT, IMMEDIATELY RETURN THE SAFETY TO THE "ON SAFE" POSITION.

IMPORTANT: UNDER NO CIRCUMSTANCES SHOULD YOU MOVE ON OR CONTINUE TO HUNT WITH YOUR SAFETY IN THE FIRE POSITION.

In the Case of a Misfire

Only rarely will modern factory ammunition experience a misfire. If this ever happens to you when shooting your Super X2, please follow these instructions carefully.

CAUTION: IN CASE OF MISFIRE, KEEP THE BARREL POINTED IN A SAFE DIRECTION, CAREFULLY OPEN THE ACTION WHILE AVOIDING DIRECT EXPOSURE TO THE BREECH BY YOURSELF AND OTHERS. REMOVE THE SHELL FROM THE CHAMBER. FULLY UNLOAD YOUR SHOTGUN, REMOVING ALL SHELLS FROM THE MAGAZINE.

Carefully inspect the ejected shell. If the primer is indented, the shell should be disposed of in a manner that would prevent accidental injury to you, others, or the environment. If there is no indentation, your gun has malfunctioned and should be serviced by a qualified gunsmith, or by a U.S. Repeating Arms Co. Authorized Repair Center (ARC).

Magazine Plug

The Super X2 is delivered with the magazine three shot adapter (plug) installed in the magazine, limiting magazine capacity to two shells in compliance with federal migratory bird regulations. If you do not wish to be limited to three shots — when it is not required by law — you can remove the three shot adapter (plug).

WHEN REMOVING THE PLUG BE CERTAIN THERE ARE NO SHELLS IN THE MAGAZINE OR CHAMBER AND KEEP THE BARREL AND MAGAZINE POINTED IN A SAFE DIRECTION AT ALL TIMES.

Remember, the plug is under spring pressure so care must be taken for safe removal. Always point the end of the magazine away from your face and in a safe direction. Never look directly down into the cap end of the open magazine.

ALWAYS WEAR EYE PROTECTION WHEN REMOVING AND REINSTALLING THE MAGAZINE'S 3-SHOT PLUG.

IMPORTANT: Use only the three-shot adapter supplied with your Super X2 or a replacement part made specifically for your Super X2 shotgun by U.S. Repeating Arms. This is a special three-shot adapter design that maximizes the performance of your gun with any load. The use of any other adapter may affect performance of the magazine system.

Removal and installation can be performed with the barrel in place or with the barrel removed from the action.

FIGURE 11

Depress the magazine spring retainer tab. Keep your free hand over the retainer.

FIGURE 12

Slowly remove the magazine spring retainer. Keep it under control with your hand, as it is under spring pressure.

REMOVAL —

1. First, make certain the gun is totally unloaded and the safety is "on safe."

CHECK THE MAGAZINE, FEED MECHANISM AND CHAMBER TO BE SURE THEY DO NOT CONTAIN ANY SHELLS.

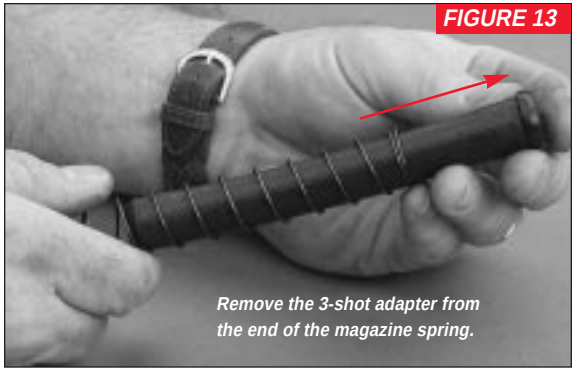
2. Unscrew the magazine cap and remove it. Remember, always point the end of the magazine away from your face and in a safe direction.

3. Remove the forearm by sliding it forward, over the gas bracket. It is also acceptable to remove the barrel as explained previously under "Initial Assembly/Takedown."

4. The magazine three-shot adapter lays underneath the magazine spring retainer locked in the forward end of the magazine tube. To remove the magazine spring retainer, depress the magazine spring retainer tab, located in the window on the magazine tube while keeping your hand on the magazine spring retainer. (See Figure 11). Slowly remove the magazine spring retainer as it is under pressure of the magazine spring. (See Figure 12).

5. As the spring pushes the retainer out of the tube the 3-shot adapter will come with it. Remove the retainer, the magazine 3-shot adapter and the spring from the magazine tube.

6. Remove the three-shot adapter from between the retainer and the spring (See Figure 13).



REINSTALLATION —

1. Depress the magazine spring back into the magazine tube and replace the magazine spring retainer over the top of the spring.

2. Align the magazine retainer tab with the rectangular slot in the magazine tube. Push the magazine spring retainer down into the magazine. Make sure the magazine spring retainer tab is locked in place in its retaining slot in the magazine.

3. Reinstall the barrel (if it was removed), the forearm and then the magazine cap as explained under "Initial Assembly/Takedown."

4. Note: In the future, should you wish to limit your gun to three shots again, unscrew the magazine cap, remove the forearm and remove the magazine spring retainer as explained previously. Hold the spring down inside the magazine tube. Then insert the tapered end of the adapter inside the spring and lightly press the front end of three-shot adapter to force the magazine spring into the magazine until the base of the three-shot adapter is level with the end of the magazine tube. Replace the magazine spring retainer, forearm and magazine cap. Make sure the magazine follower remains in place inside the rear of the magazine tube.

TRIGGER GROUP DISASSEMBLY/REASSEMBLY

One of the advantages of a Super X2 is the ability to easily disassemble the action for cleaning. Under very harsh weather conditions and in dirty environments just knowing that parts are clean and lightly oiled can add an extra measure of confidence to your hunt.

Make sure you have a clean place to work and a good place to put the components as they are disassembled.

Wear eye protection at all time. Never disassemble beyond what is explained and shown in this manual. Full disassembly of all basic components is shown at right (See Figure 14).

Disassembling the action can be done in the field, but remember, there are small parts involved, some of which

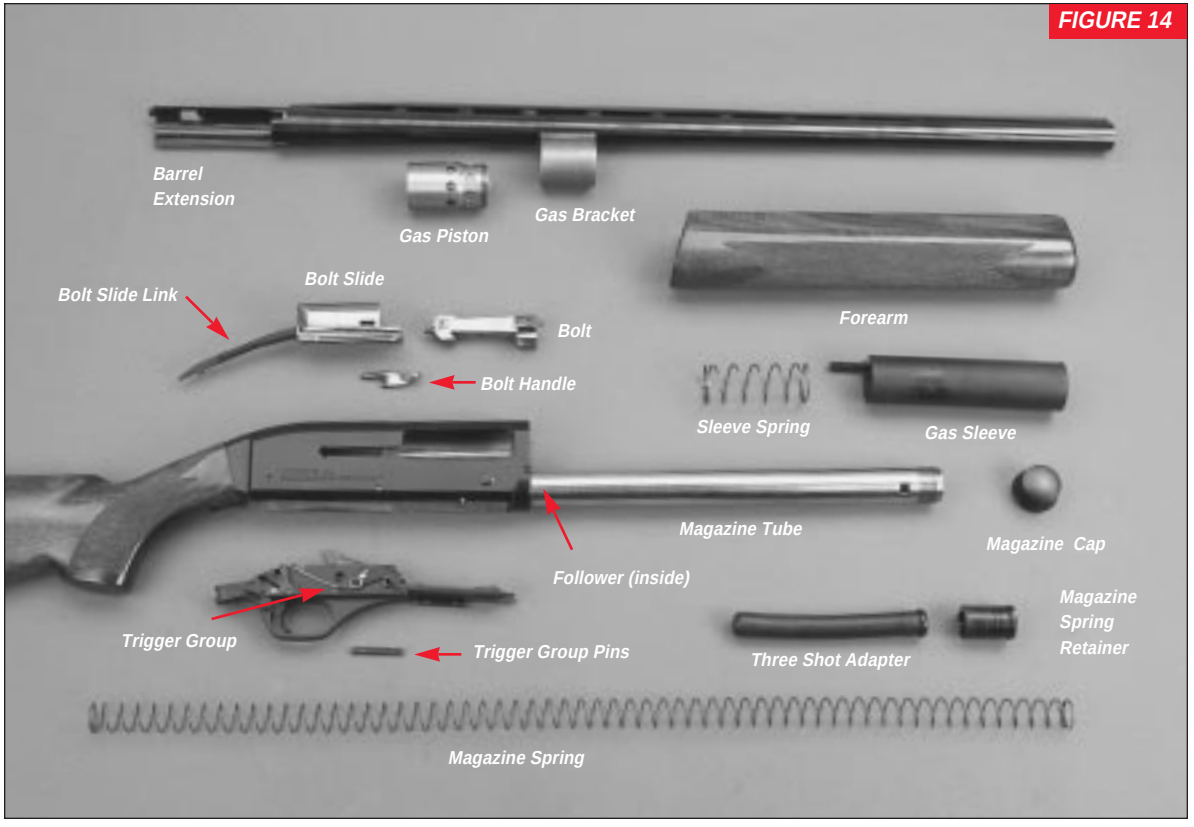


FIGURE 14
Barrel Extension
Gas Piston
Gas Bracket
Bolt Slide Link
Bolt Slide
Bolt
Forearm
Bolt Handle
Sleeve Spring
Gas Sleeve
Magazine Tube
Magazine Cap
Follower (inside)
Trigger Group
Trigger Group Pins
Three Shot Adapter
Magazine Spring Retainer
Magazine Spring

are under spring tension.

BEFORE ANY ASSEMBLY OR DISASSEMBLY PROCEDURES FIRST, MAKE CERTAIN THE GUN IS TOTALLY UNLOADED AND THE "SAFETY" IS THE "ON SAFE" POSITION. BE CERTAIN THERE ARE NOT SHELLS IN THE MAGAZINE, CHAMBER OR FEED MECHANISM. PLACE THE SAFETY IN THE "ON SAFE" POSITION.

ALWAYS WEAR EYE PROTECTION WHEN PERFORMING ANY MAINTENANCE OR DISASSEMBLY.

How to remove the trigger group —

Removing the trigger guard group is another necessary procedure in performing thorough maintenance of your shotgun. It is easy to do, and removing it allows you to perform cleaning and maintenance whenever and wherever required. With both the trigger guard group and bolt assembly removed, it is easy to wipe out any debris or moisture that sometimes accumulates in the receiver.

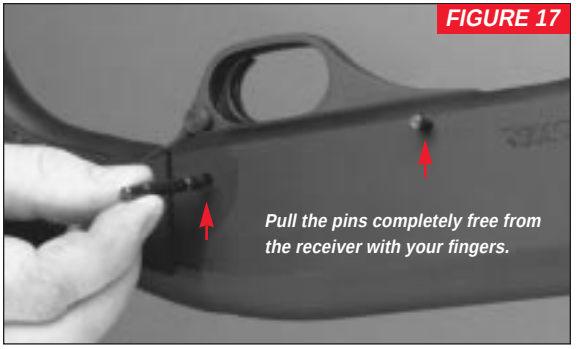
1. Make sure the gun is unloaded. Place the safety in the "ON SAFE" position and leave it there during disassembly and cleaning. This assures that the hammer does not inadvertently fall forward during cleaning. Full disassembly involves removal of the bolt assembly and the trigger group. Any disassembly beyond this should only be performed by a competent gunsmith.

FIGURE 15
Carefully lower the bolt forward to the closed position. You can damage the receiver by slamming the bolt closed with no barrel installed.

2. Under most circumstances, first remove the barrel and gas system components as explained under "Initial Assembly/Takedown." It is acceptable for the trigger group to be removed without removing the barrel — although it makes sense to remove the barrel if you are cleaning your gun.

3. After removing the barrel and forearm, it is good practice to immediately screw the magazine cap back onto the magazine.

4. VERY IMPORTANT: The bolt must be slowly moved from the open to the forward, closed position. You must



hold the bolt handle with one hand while depressing the carrier release button with the other (See Figure 15). Use extreme caution. If you allow the bolt assembly to slam closed with the barrel removed you can damage the receiver and affect the function of your gun.

5. Place your gun with the trigger guard facing up, on a suitable surface that will protect the receiver finish and stock.

6. With the gun inverted, (trigger guard up) use a drive punch or similar object to push inward on the trigger group pins, using caution not to scratch the receiver (see Figure 16). In the field the end of the bolt slide link can be used to start the two pins out (of course you will have to remove the bolt assembly — described below — before doing this). Trigger group pins may be removed from either side of the receiver. Push the trigger group pins clear through to the other side of the receiver. Once the pins are started out they can be pulled the rest of the way out using your fingers (See Figure 17).

7. Grasp the trigger group and pull it up and out of the receiver (See Figure 18).

8. Perform any cleaning of the parts and receiver cavity as necessary.

DO NOT DISASSEMBLE THE TRIGGER GROUP BEYOND THIS POINT. ANY MAINTENANCE BEYOND THIS POINT SHOULD BE DONE BY A COMPETENT GUNSMITH, OUR SERVICE CENTER OR A U.S. REPEATING ARMS AUTHORIZED REPAIR CENTER.

HOW TO REASSEMBLE THE TRIGGER GROUP —

1. Make Sure the bolt is in the forward position. Use extreme caution. If you allow the bolt assembly to slam closed with the barrel removed you can damage the receiver and affect the function of your gun. If the bolt is not already forward, carefully and slowly lower it to the closed position as explained previously.

2. Insert the trigger group back into the receiver. The holes in the trigger group should line up with holes on each side of the receiver. (If the hammer on the trigger assembly has been inadvertently uncocked during cleaning , it helps assembly if it is recocked. Do this by simply by pulling it back fully until it locks rearward.)

3. Reinsert the trigger guard pins, pushing them in with your hand or gently tapping them into place with a plastic or wooden mallet, again using caution not to scratch the receiver.

4. Complete assembly by installing the gas system, barrel and forearm as explained under "Initial Assembly/Takedown."

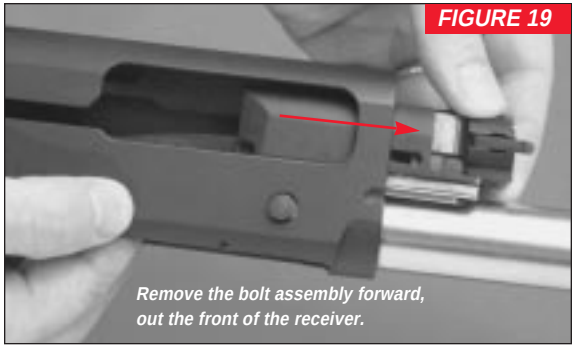
BOLT DISASSEMBLY/REASSEMBLY

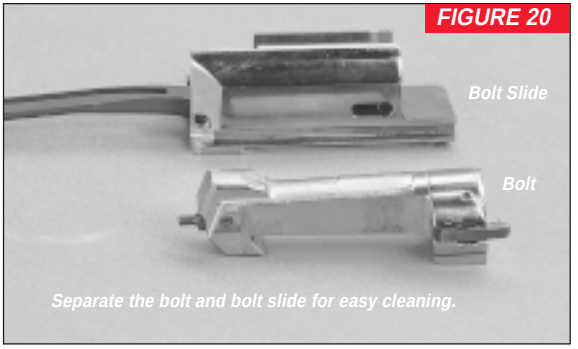
The bolt can be removed for normal maintenance or if the action becomes excessively dirty or wet. The Super X2 is designed to allow full disassembly of the bolt assembly in the field, without any tools. Although it is possible to remove the bolt with the trigger group in place, the correct procedure when removing the bolt is to always remove the trigger group first. Removing the bolt without removing the trigger group could allow the bolt to spring out the front of the receiver, damaging or losing parts or causing injury to you or others.

HOW TO REMOVE THE BOLT ASSEMBLY —

1. First, always remove the barrel assembly as explained earlier in this manual under "Initial Assembly/Takedown."

2. VERY IMPORTANT: As explained previously, with the barrel removed you MUST carefully and slowly lower the bolt forward from the open position to the forward,





closed position. To do this hold the bolt handle with one hand while depressing the carrier release button with the other to prevent slamming the bolt forward and damaging the receiver.

3. Remove the trigger group as explained under "Trigger Group Disassembly/Reassembly."

4. Remove the bolt handle by pulling the handle outward, to the right, away from the bolt. It is held in place with a ball-detent system that may take a little effort to pull free.

5. Slide the bolt and bolt slide forward and out of the front of the receiver (See Figure 19).

6. The bolt and bolt slide can be separated for cleaning (See Figure 20). Perform any cleaning of the bolt and receiver cavity as necessary.

DO NOT DISASSEMBLE THE BOLT ASSEMBLY BEYOND THIS POINT.

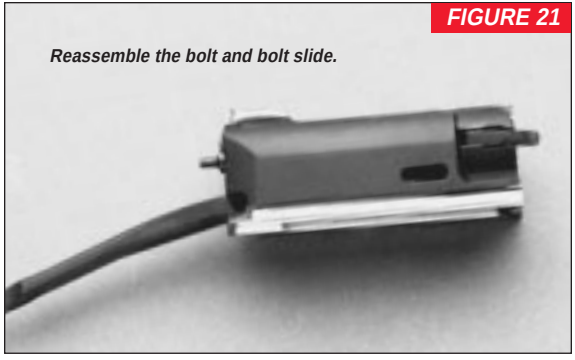
How to reinstall the bolt assembly —

Under usual conditions, the trigger group should also have been removed at this point. Reinstallation of the bolt assembly is somewhat easier with the trigger group removed.

1. Reassemble the bolt and bolt slide as shown (See Figure 21).

2. Place the bolt assembly back in the receiver, bolt slide link end first (See Figure 22). Line the rails on the bolt slide with slots in the bottom of the receiver.

3. Guide the bolt slide link into its socket in the recoil



spring follower (See Figure 23). The socket can be seen at the rear of the receiver cavity. It is the cupped-shaped part that forms a recess for the bolt side link to rest in. Become familiar with how the slide fits into the socket. It helps to keep the receiver pointing slightly upward to assure that the bolt slide link does not come out of the recoil spring follower until the barrel is reinstalled. VERY IMPORTANT: If when your gun is fully assembled it will not function properly and the action will not open, the bolt slide link is likely not properly in place in the recoil spring follower socket. (It is possible, with practice to fit the bolt slide link into the recoil spring follower even with the trigger group installed, by holding the gun vertically and aligning the link into the socket while looking through the bolt handle slot on the right side of the receiver. This is handy if you are simply reattaching the barrel assembly after storage and the bolt has inadvertently moved forward and the bolt slide link has come out of the socket.)

4. Replace the bolt handle by pushing it in (cupped side toward the front) until it engages in the ball-detent. (See Figure 24).

5. Again, observe that the bolt slide link and recoil spring follower are properly engaged. (You can also confirm this by pulling back a bit on the bolt handle. You will feel the recoil spring compress as you pull back. Do this very slowly, and make sure you control the bolt as the bolt slide link may not be properly seated into the recoil spring follower socket. Repeat step 3 above, making sure that they are

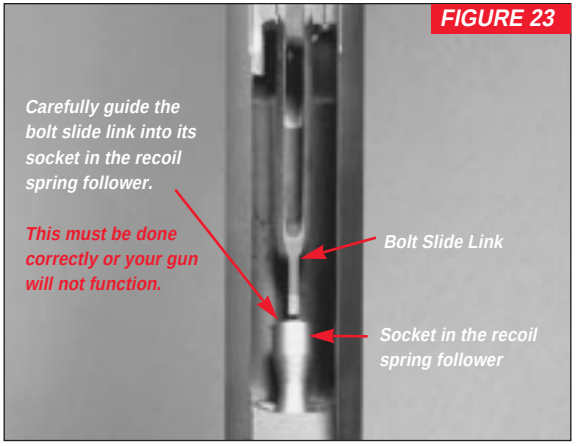


FIGURE 23
Carefully guide the bolt slide link into its socket in the recoil spring follower.
This must be done correctly or your gun will not function.
Bolt Slide Link
Socket in the recoil spring follower

installed correctly. Remember the bolt cannot lock rearward with the trigger group removed.

6. Reinstall the trigger group as explained previously (if it was removed).

7. With the trigger group installed, pull the bolt fully back until it locks in the rearward position.

TO PREVENT SLAMMING THE BOLT FORWARD AND DAMAGING THE RECEIVER, DO NOT PRESS THE CARRIER RELEASE BUTTON UNTIL INSTALLATION IS COMPLETE.

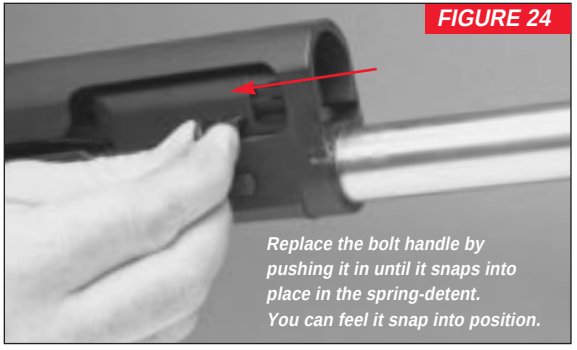


FIGURE 24
Replace the bolt handle by pushing it in until it snaps into place in the spring-detent.
You can feel it snap into position.

8. Replace the gas system, barrel and forearm as explained previously.

9. Again, work the bolt fully to the rear until it locks open. If it will not complete its rearward movement and will not lock rearward, you likely have not properly installed the bolt slide link into its socket in the recoil spring follower. Refer to step 3 above.

10. With all parts installed (including the barrel) your Super X2 is fully assembled. It is now allowable to lock the bolt rearward then let is slam forward (closed) by pressing the carrier release button. Be sure to always keep your fingers clear of the ejection port when closing the action.

INVECTOR® PLUS CHOKE TUBE SYSTEM

The Super X2 is fitted with one of the most popular and universally accepted choke tube systems on the market: Invector-Plus. Your Super X2 Shotgun is specially designed for this system only. This means:

- It has a back-bored barrel.
- It is threaded to accept Invector-Plus choke tubes only.

The Invector-Plus system allows you to configure your Super X2 for the pattern and/or choke constriction your hunt demands. The system gives you the most highly engineered choke tapers — designed to produce the best possible patterns for target and field situations. Plus, it is extremely easy to switch choke constrictions to match your shooting conditions. Invector-Plus tubes are fully steel and lead shot compatible. Most Invector-Plus choke tubes fit flush with the muzzle when installed. A special choke tube wrench is provided to remove and tighten these tubes.

Invector-Plus choke tubes are NOT interchangeable with any other choke tubes on the market including chokes listed as "Standard Invector" or Winchester's current line of "WinChoke" choke tubes.

USE ONLY CHOKE TUBES MARKED INVECTOR PLUS IN YOUR SUPER X2. USE ONLY THE APPROPRIATE GAUGE OF INVECTOR PLUS CHOKE TUBES AS MARKED ON YOUR SUPER X2 SHOTGUN.

Failure to follow these warnings may damage your gun and cause injury to yourself and others. A special "Plus" choke tube wrench is provided to remove and tighten Invector-Plus choke tubes.

DO NOT FIRE THIS SHOTGUN WITHOUT HAVING AN INVECTOR CHOKE TUBE INSTALLED. PERMANENT DAMAGE MAY RESULT TO THE THREADS.

CAUTION: WHENEVER HANDLING ANY SHOTGUN FOR THE PURPOSE OF REMOVING OR INSTALLING A CHOKING DEVICE, MAKE ABSOLUTELY CERTAIN THE GUN IS FULLY UNLOADED, AND THE BOLT OR BREECH IS OPEN! NEVER ATTEMPT TO REMOVE OR INSTALL A SHOTGUN CHOKING DEVICE ON A LOADED FIREARM!

TUBE REMOVAL —

1. ***UNLOAD YOUR SUPER X2 SHOTGUN FULLY. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.***

2. Open the action, locking it rearward, and place the "safety" in the "on safe" position.

3. Use the Invector Plus wrench to loosen the tube, turning it counterclockwise. Finger twist the tube the rest of the way out of the barrel.

TUBE INSTALLATION —

1. ***UNLOAD YOUR SUPER X2 SHOTGUN FULLY. INSPECT THE CHAMBER, FEED MECHANISM AND MAGAZINE TO MAKE SURE THEY DO NOT CONTAIN ANY SHELLS.***

2. Open the action, locking it rearward, and place the "safety" in the "on safe" position.

3. Before installing a tube, check the internal choke tube threads in the muzzle, as well as the threads on the Invector-Plus choke tube to be sure they are clean. Lightly oil the threads with a high quality light weight oil.

4. Using your fingers, screw the appropriate tube into the muzzle end of the barrel, tapered end first, notched end outward. When it becomes finger tight, use the Invector-Plus choke tube wrench to firmly seat the tube.

THE INVECTOR PLUS CHOKE TUBE SHOULD BE PERIODICALLY CHECKED TO ASSURE THAT IT IS TIGHT AND FIRMLY SEATED. BEFORE CHECKING, FOLLOWING THE SAFETY GUIDELINES OUTLINED ABOVE.

SELECTING THE CORRECT INVECTOR-PLUS TUBE —

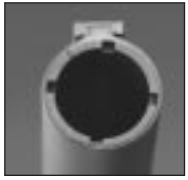
The Invector-Plus choke system is fully compatible with factory lead or steel shot loads. The conversion chart includes both lead and steel shot information. Lead and steel shot perform differently in tubes with the same choke constriction. For this reason, both lead and steel designations have proven necessary. In fact, even larger steel shot diameters result in different patterns than smaller steel shot sizes. Each designation is inscribed on each choke tube.

To help you choose the correct choke tube for each target shooting and hunting situation, all Invector-Plus choke tubes are inscribed on the side with abbreviations for the patterns they produce with both lead and steel shot.

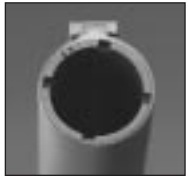
Each tube also features identification notches located on the top rim of each tube (see Figure 25 and 26). These notches are a code to allow you to determine the choke designation while the tube is installed. Rim notches refer specifically to lead shot. You will need to use the chart below to cross-reference from lead to steel, and determine the appropriate tubes for your ammunition and hunting/shooting situation.

Tube Notch Codes (Lead shot designations)

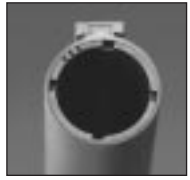
FIGURE 25



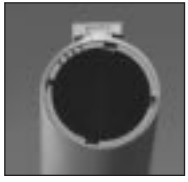
1 Notch: Full



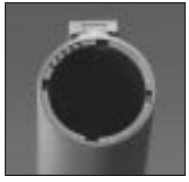
2 Notches: Improved Modified



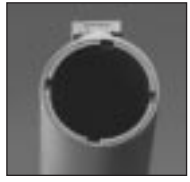
3 Notches: Modified



4 Notches: Improved Cylinder



5 Notches: Skeet



No Notches: Cylinder

Small notches are the choke code.
Large notches are for the choke tube wrench.

Extra Full Turkey Special

FIGURE 26

No rim notch code. Knurled extension protrudes beyond muzzle.
Large notches are for choke tube wrench.

CHOKE TUBE RIM CODES AND PATTERNING

Rim Notches	Pattern With Lead Shot	Pattern With Steel Shot
Knurled**	X-Full Turkey	**
I	Full	*
II	Imp. Modified	Full[1]
III	Modified	Full[1]
IIII	Imp. Cylinder	Modified
IIIII	Skeet	Imp. Cylinder
No Notches	Cylinder	Cylinder

• Not for use with steel shot. Using an over-tight choke constriction with steel shot will result in an ineffective "blown" pattern.
***** Extra Full Special with knurled rim. Do not use with steel shot.***
[1]When more than one choke designation is listed for a given steel shot pattern, use the more open choke listed for high velocity, larger shot size steel loads.

Use of Extra Barrels

A good way to extend the utility and usefulness of your new Super X2 is with an extra barrel. All Winchester Super X2 semi-auto shotgun barrels are completely interchangeable within gauge and chamber length. No special fitting is required.

Some important restrictions must be observed:

1) Never use a barrel with a 3 1/2" chamber in a Super X2 designed for barrels with a 3" chamber.

2) Never use a barrel with a 3" chamber in a Super X2 designed for barrels with a 3 1/2" chamber.

3) Never use any other barrel from any other manufacturer on your Super X2. Some other brands may seem similar, but the barrels are not interchangeable.

5) Never use any barrel from a Winchester shotgun made in the past, including barrels for the original Super X Model 1 shotgun.

FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN INJURY TO YOURSELF OR OTHERS.

Cleaning and Maintenance Suggestions

Your Super X2 will function better and more reliably over a longer period of time if it is properly maintained and kept clean.

BEFORE PERFORMING ANY CLEANING PROCEDURES, ALWAYS MAKE CERTAIN THERE ARE NO SHELLS IN THE CHAMBER, MAGAZINE OR ACTION/FEED AREAS.

You should clean your Super X2 after every day of shooting and more often if it becomes excessively dirty.

A minimum cleaning includes wiping down the action and oiling key parts. Most regular maintenance will also include cleaning the barrel. If you encounter a function problem (tight action when working the forearm) be sure to give your gun a thorough cleaning to see if it solves the problem before seeking the services of our service facility or a competent gunsmith. To clean your firearm, adhere to the following general guidelines.

Cleaning procedures —

BE CERTAIN YOUR GUN'S CHAMBER AND MAGAZINE ARE UNLOADED. ALWAYS WEAR PROTECTIVE SAFETY GLASSES DURING ALL CLEANING PROCEDURES. KEEP AMMUNITION AWAY FROM THE CLEANING

AREA. DO NOT TEST THE FUNCTION OF YOUR FIREARM WITH LIVE AMMUNITION.

ALWAYS PLACE THE SAFETY IN "ON SAFE" POSITION BEFORE BEGINNING ANY CLEANING PROCEDURE.

1. Use a cleaning rod with a tip and patch suitable for the size of your Super X2's bore. Make sure the patch is large enough for a snug fit in the bore. Insert the rod and patch into the barrel at the receiver end and run it back and forth several times.

2. Inspect the chamber and bore for lead and powder fouling. A normal amount of powder residue can be expected and is not serious. It can usually be removed by repeating step one, using a patch saturated with solvent. If or when fouling should become heavy, it can be removed with a brass bore brush. Dip or spray the brush with solvent and scrub the chamber and bore until the fouling is removed. To prevent brass bristles from breaking off, the brush should be pushed completely through the bore before being withdrawn.

3. After fouling has been removed the bore should be wiped dry. Then pass a slightly oiled patch through the bore, for preservation. A fine, light gun oil is recommended.

4. Wipe all exposed metal surfaces of the receiver, forearm and barrel with a clean rag. Finger marks should be removed because they provide a place where moisture can accumulate. Any dried oil in the receiver area should also be removed.

5. Lightly oil your gun at the points described under "Oiling the Action" explained earlier in this manual. Ordinary good judgment will, of course, indicate that the metal of the gun should receive a light film of oil any time the gun has been exposed to weather or handling. This is very important and must be done with every gun — even stainless steel models. Remember, the polished, finely fitted surfaces of the receiver and action mechanisms must always have a thin film of oil. Make sure that the surfaces of the breech bolt are especially clean and lightly oiled with a high quality gun oil.

6. ***INSPECT THE BARREL AND CHAMBER. MAKE CERTAIN THAT NO PATCHES HAVE BEEN INADVERTENTLY LEFT IN THEM. REMOVE ANY THAT REMAIN.***

7. Wipe all wood surfaces with a soft cloth.

8. When transporting only, store your Super X2 in a quality protective case to prevent scratches and dents. Store in a dry place to prevent corrosion. Store away from children.

MAKE SURE YOUR SHOTGUN IS UNLOADED AND ALWAYS STORE AMMUNITION SEPARATELY.

DO NOT TAKE YOUR GUN'S ACTION APART BEYOND WHAT IS EXPLAINED IN THIS MANUAL.

This is a specialized, finely fitted mechanism; any attempt to disassemble the trigger group or bolt mechanism may mar it for life. It is unnecessary, and may do damage to the inner mechanism, to disassemble these components for routine cleaning and oiling. Of course, misfortunes (such as dropping your gun in water) require appropriate attention, and in such circumstances we recommend you immediately take your gun to a competent gunsmith.

CLEANING THE ACTION AND TRIGGER GROUP —

1. When the action becomes excessively dirty, remove the trigger group and bolt assembly from the receiver as explained under "Bolt Disassembly/Reassembly." Clean with a good quality light oil, a gun solvent or spray "scrub" as necessary, using an old toothbrush to loosen any caked-on grime. Wipe the receiver cavity clean. Lightly oil the cavity and wipe it dry. No further disassembly is required for cleaning.

2. Reassemble as explained previously and wipe all exposed metal surfaces with an oiled cloth, making sure to wipe clean all finger marks where moisture will accumulate.

3. The barrel and action should be inspected to assure that all cleaning patches have been removed and not inadvertently left in the barrel or action.

CLEANING THE GAS SYSTEM —

1. Remove the gas piston and piston sleeve from the magazine tube. Do no attempt to disassemble gas piston components, it is not necessary for good maintenance and risks loosing parts and damaging your gun. Spray the magazine tube with a good quality powder solvent and wipe clean.

2. Spray the piston and bracket with a good quality powder solvent. Brush them thoroughly to remove any deposits (an old toothbrush is ideal). Spray the inside and wipe off any buildup. ***NEVER USE A STEEL BRUSH ON ANY OF THE GAS SYSTEM COMPONENTS.***

3. Complete the cleaning of the gas system by applying a very light film of gun oil to all parts for protection and lubrication

CLEANING THE MAGAZINE SYSTEM —

It is a good idea — especially if your gun becomes excessively dirty or very wet — to occasionally clean the magazine system. Remove the magazine spring retainer, three shot plug, magazine spring and magazine follower by following the instructions under "Magazine Plug" detailed earlier in this manual.

Clean the inside of the tube using a rod and patch just as you would clean a barrel. Carefully wipe off the spring and 3-shot adapter. Very lightly oil each component. Reinstall all parts as explained earlier.

CLEANING THE INVECTOR-PLUS CHOKE SYSTEM —

1. Do not use a brass brush to clean your barrel unless a choke tube is installed in the barrel. Bristles could break off and lodge in the threads, making installation and removal difficult.

2. Regularly remove your gun's tube in order to clean and oil the threads inside the barrel, as well as on the choke tube itself. This will protect the threads from being damaged and also prevent a dirt build-up that would cause the choke tube to become difficult to remove from the barrel. Clean the threads with solvent and a small, soft brush like a toothbrush. Wipe completely clean and leave a thin film of clean oil on the threads: both on the tube and in the barrel. The threads of the choke tube and the internal threads of the barrel should be cleaned after each use and before the installation of a tube.

3. Be careful when removing/installing a tube. Use the specially designed wrench. Damage can result to both choke tube and barrel when attempting to remove sticky choke tubes.

4. Never fire your shotgun or run cleaning tools through the barrel of any choke-tubed gun without having the choke tube installed.

OTHER CLEANING SUGGESTIONS —

• Never pour large quantities of oil into the receiver or other parts. It can drain down to the wood and soften it — and cause permanent damage and loosening of the stock.

• After extended periods of heavy use, your shotgun should be taken to a qualified gunsmith to have the action disassembled for professional cleaning and lubrication.

• Camouflage and synthetic-stocked models require the same care and cleaning as non-camouflage. Use the same oils and solvents as described previous in this manual.

NEVER ATTEMPT TO TAKE YOUR SUPER X2 APART FURTHER THAN EXPLAINED IN THIS MANUAL.

This is a specialized, finely fitted mechanism. You may permanently mar it by attempting to disassemble the inner mechanism assemblies. If further disassembly for service or cleaning is required, take your gun to a U. S. Repeating Arms Company recommended Authorized Repair Center or a competent gunsmith as explained under "Service or Repair."

Ordering Parts

To order parts, please write our parts department and furnish the following: your name, address, and telephone number. Also specify the caliber, model, serial number and grade of your Winchester gun. When we receive your request, we will send an order form and a parts breakdown with prices.

Write to:

Parts Department
U.S. Repeating Arms Company, Inc.
344 Winchester Avenue
New Haven, Connecticut 06511-1970

CAUTION: PARTS ARE MADE FOR WINCHESTER BRAND GUNS MANUFACTURED BY OR FOR U.S. REPEATING ARMS COMPANY, INC., AND SHOULD NOT BE USED IN OTHER GUNS EVEN THOUGH MODELS MAY BE SIMILAR. IMPROPERLY FITTED PARTS MAY BE DANGEROUS.

Service or Repair

If your Winchester firearm should ever need repair or service, please utilize one of the world-wide network of U.S. Repeating Arms Company Authorized Repair Centers (ARC) for Winchester firearms. A list of ARCs is packaged with your new gun. If you have any questions about how to obtain service, or to obtain a new list of ARCs, call us at:

1-203-789-5000

QUESTIONS

If you have other questions about Winchester rifles and shotguns, call or write our Customer Service Department:

Customer Service
U.S. Repeating Arms Company, Inc.
275 Winchester Avenue
Morgan, Utah 84050-9333
Phone: 1-800-945-5237

WINCHESTER-GUNS.COM

U.S. Repeating Arms Company offers an information resource for you on the world wide web.

- List of authorized repair centers.
- Customer service information.
- Answers to many technical and historical questions.
- Links to helpful sites.

Go to: **www.winchester-guns.com**

You Are Responsible For Firearms Safety.

As a gun owner, you accept a set of demanding responsibilities. How seriously you take these responsibilities can mean the difference between life and death. Failure to follow any of these instructions can cause extensive damage to your gun and/or possible serious injury or death to yourself and others. There is no excuse for careless or abusive handling of any firearm. At all times handle any firearm with intense respect for its power and potential danger. **READ AND UNDERSTAND all of THE CAUTIONS AND PROPER HANDLING PROCEDURES OUTLINED IN THIS BOOKLET BEFORE USING YOUR NEW FIREARM.**

1. ***ALWAYS KEEP THE MUZZLE OF ANY FIREARM POINTED IN A SAFE DIRECTION.***
Do this even though you are certain the firearm is unloaded. Never point any firearm at anything you do not intend to shoot. Be extremely alert and aware of all persons and property within the range of your ammunition.

2. ***NEVER RELY TOTALLY ON YOUR SHOTGUN'S MECHANICAL "SAFETY" DEVICE.***
Always assume that your gun can be fired at any time, even with all the safety mechanism engaged. The word "safety" describes a gun's trigger block mechanism, sear block mechanism, hammer block mechanism or firing pin block mechanism. These mechanical devices are designed to place your gun in a **SAFER** status. No guarantee can be made that the gun will not fire even if the "safety" is in the "on safe" position. See **"Operation of the Safety"** in your owner's manual for instructions on operation of your gun's "safety."

3. ***LIKE ANY MECHANICAL DEVICE, A "SAFETY" CAN SOMETIMES FAIL; IT CAN BE JARRED OR INADVERTENTLY MANIPULATED INTO AN UNSAFE CONDITION.***
Mechanical "safeties" merely aid safe gun handling and are no excuse for pointing your shotgun's muzzle in an unsafe direction.
While it is a good idea to "test" your shotgun's mechanical "safeties" periodically for proper function, never test them while your firearm is loaded or pointed in an unsafe direction. Safe gun handling does not stop with your gun's mechanical "safety" devices -- it starts there. Always treat this shotgun with the respect a loaded, ready-to-fire firearm. ***NEVER TEST THE MECHANISM OF ANY FIREARM WHILE IT IS LOADED OR POINTED IN AN UNSAFE DIRECTION.***

4. ***WHENEVER YOU HANDLE A FIREARM, OR HAND IT TO SOMEONE MAKE SURE IT IS COMPLETELY UNLOADED.***
Always open the action immediately and visually check the chamber magazine. Make certain the chamber does not inadvertently contain any ammunition. Always keep the chamber empty and the "safety" in the "on safe" position unless shooting is imminent.

5. ***DO NOT TRANSPORT ANY FIREARM LOADED. KEEP ALL FIREARMS UNLOADED DURING TRANSPORT, WHETHER IN A SCABBARD, GUN CASE, OR OTHER CONTAINER.***

6. ***HUNTING FROM ELEVATED SURFACES SUCH AS TREE STANDS IS DANGEROUS.***
Doing so may increase the risk of handling a firearm. The following rules should always be observed by you and those you hunt with: ***Always*** make certain that the stand being used is safe and stable. ***Always*** make certain that your firearm is unloaded when it is being taken up and down from the stand. ***Always*** make certain that your firearm is not dropped from the stand, or dropped while it is being taken up or down from the stand. ***Remember***, a loaded firearm may discharge when dropped, even with the safety in the "on safe" position.

7. ***BEWARE OF BARREL OBSTRUCTION.***

Do this for the safety of both your gun and yourself. Mud, snow, and an infinite variety of other objects may inadvertently lodge in a barrel bore. It takes only one small obstruction to cause dangerously increased pressures that can ruin (swell or rupture) the finest shotgun barrel. ***BEFORE CHECKING FOR A BARREL OBSTRUCTION, BE CERTAIN YOUR FIREARM IS FULLY UNLOADED.***

Make sure no live rounds are in the chamber. Place the safety in the "on safe" position, open the breech or action and look through the barrel to be sure it is clear of any obstruction. If an obstruction is seen, no matter how small it may be, clean the bore with a cleaning rod and patch as instructed for your particular firearm. Before the first firing, clean the bore with a cleaning rod and patch, and wipe away any anti-rust compounds in the action/chamber areas.

8. ***ALWAYS UNLOAD ALL FIREARMS WHEN NOT IN USE.***

As a safety precaution, it is preferable to disassemble your gun for storage. Your responsibilities do not end when your firearm is unattended. Store your gun and ammunition separately -- well beyond the reach of children. Take all safeguards to ensure your firearm does not become available to untrained, inexperienced or unwelcome hands.

9. ***USE THE PROPER AMMUNITION.***

The barrel and action of all Browning firearms have been made with substantial safety margins over the pressures developed by established American commercial loads. Nevertheless, Browning assumes no liability for incidents which occur through the use of cartridges of nonstandard dimensions which develop pressures in excess of commercially available ammunition with standards established by the Sporting Arms and Ammunitions Manufacturers' Institute (SAAMI).

BE ALERT TO THE SIGNS OF AMMUNITION MALFUNCTION.

If you detect an off sound or light recoil when ammunition is fired, ***DO NOT LOAD MORE AMMUNITION INTO THE CHAMBER.*** Open the action and remove all ammunition from the chamber. With the action open, glance down the barrel to make sure that a wad or other obstruction does not remain in the barrel. If there is an obstruction, completely clear the barrel before loading and firing again. Failure to follow these instructions can cause extensive damage to your gun and possible serious injury to yourself and others.

10. ***MAKE SURE OF ADEQUATE VENTILATION IN THE AREA THAT YOU DISCHARGE A FIREARM. WASH HANDS THOROUGHLY AFTER EXPOSURE TO AMMUNITION OR CLEANING A FIREARM.***

Lead exposure can be obtained from discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition. Lead is
a substance that has been known to cause birth defects, reproductive harm and other serious injury.

11. ***NEVER INSERT A SHELL OF THE INCORRECT GAUGE IN ANY SHOTGUN***. The gauge of your shotgun is marked on the side of the barrel. Store all shells of different gauges in completely separate and well-marked containers. Never store shells of mixed gauges in a common container or in your pockets.

EXAMINE EVERY SHELL YOU PUT IN YOUR GUN. NEVER PUT A 20 GAUGE SHELL IN A 12 GAUGE GUN. The most common way to bulge or rupture a shotgun barrel is to drop a 20 gauge shell into a 12 gauge chamber. The 20 gauge shell, unfortunately, will not fall completely through the barrel; its rim is caught by the front of a 12 gauge chamber. Your gun will misfire (with the chamber appearing to be empty). It is then possible to load a 12 gauge shell behind the 20 gauge shell. If the 12 gauge shell is then fired, the result will be a so-called “12-20 burst” which can cause extensive damage to your gun and possible serious injury to you and others.

12. ***USE SHELLS OF CORRECT LENGTH.***
The size of the chamber is inscribed, along with gauge and choke designations, on the side of the barrel. Do not use 31/2" shotgun shells in a shotgun or barrel with a 2 3/4" chamber or 3" chamber. Do not use 3" shells in a shotgun chambered for a 2 3/4" shells. Doing so can result in a build-up of dangerously high pressures that may damage your gun and possibly cause serious injury to yourself or others.

13. ***DO NOT SNAP THE FIRING PIN ON AN EMPTY CHAMBER -- THE CHAMBER MAY NOT BE EMPTY!***
Treat every gun with the respect due a loaded gun, even though you are certain the gun is unloaded.

14. ***KEEP YOUR FINGERS AWAY FROM THE TRIGGER WHILE LOADING AND UNLOADING UNTIL YOU ARE READY TO SHOOT.***

15. ***BE SURE OF YOUR TARGET AND BACKSTOP***. Particularly during low light periods. Know the range of your ammunition. Never shoot at water or hard objects.

16. ***ALWAYS UNLOAD THE CHAMBER AND MAGAZINE OF ANY FIREARM BEFORE CROSSING A FENCE, CLIMBING A TREE, JUMPING A DITCH OR NEGOTIATING OTHER OBSTACLES.***
Never lean or place your loaded shotgun on or against a fence, tree, car or other similar object.

17. ***WEAR EYE AND EAR PROTECTION WHEN SHOOTING***. Unprotected, repeated exposure to gunfire can cause hearing damage. Wear ear protectors (shooting earplugs or muffs) to guard against such damage. Wear shooting glasses to protect your eyes from flying particles. Always keep a safe distance between the muzzle of your firearm and any persons nearby, as muzzle blast, debris and ejecting shells could inflict serious injury. Also, wear eye protection when disassembling and cleaning all firearms to prevent the possibility of springs, spring-tensioned parts, solvents or other agents from contacting your eyes.

18. ***DROPPING A LOADED GUN CAN CAUSE AN ACCIDENTAL DISCHARGE.***
This can occur even with the "safety" in the "on safe" position. Be extremely careful while hunting or during any shooting activity to avoid dropping any firearm.

19. ***IF ANY FIREARM FAILS TO FIRE, KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.***
Hold this position for a minimum of 30 seconds. Carefully open the action and remove the shell. If the primer is indented, the shell should be disposed of in a way that cannot cause harm. If the primer is not indented, your firearm should be examined by a qualified gunsmith and the cause of the malfunction should be corrected before further use.

20. ***BE DEFENSIVE AND ON GUARD AGAINST UNSAFE GUN HANDLING AROUND YOU AND OTHERS***. Don’t be timid when it comes to gun safety. If you observe other shooters violating any of these safety precautions, politely suggest safer handling practices.

21. ***BE CERTAIN YOUR SHOTGUN IS UNLOADED BEFORE CLEANING.***
Because so many accidents occur when a firearm is being cleaned, special and extreme care should be taken to be sure your gun is unloaded before disassembly, cleaning and reassembly. Keep ammunition away from the cleaning location. Never test the mechanical function of any firearm with live ammunition.

22. ***SUPERVISE AND TEACH FIREARMS SAFETY TO ALL MEMBERS OF YOUR FAMILY -- ESPECIALLY TO CHILDREN AND NONSHOOTERS.***
Closely supervise newcomers to the shooting sports. Encourage enrollment in hunting/shooting safety courses.

23. ***NEVER DRINK ALCOHOLIC BEVERAGES OR TAKE ANY TYPE OF DRUGS BEFORE OR DURING SHOOTING.***
Your vision and judgment could be dangerously impaired, making your gun handling unsafe to you and to others.

24. ***PERFORM PERIODIC MAINTENANCE -- AVOID UNAUTHORIZED SERVICING.***
Your firearm is a mechanical device which will not last forever, and as such, is subject to wear and requires periodic inspection, adjustment and service. Browning firearms should be serviced by a Browning Recommended Service Center or by Browning's service facility in Arnold, Missouri. Browning cannot assume any responsibility for injuries suffered or caused by unauthorized servicing, alterations or modifications of Browning firearms.

25. ***READ AND HEED ALL WARNINGS*** in these instructions, on ammunition boxes and with all accessories that you install on your firearm. It is your responsibility to secure the most up-to-date information on the safe handling procedures of your Browning gun. Browning assumes no liability for incidents which occur when unsafe or improper gun accessories or ammunition combinations are used.

26. Browning reserves the right to refuse service on firearms that have been altered, added to or substantially changed. Removal of metal from barrel(s), or modification of the firing mechanism and/or operating parts may lead to Browning’s refusal of service on such firearms. Browning will charge the owner for parts and labor to return the firearm to original Browning specifications.

DO NOT, UNDER ANY CIRCUMSTANCES, ALTER THE TRIGGER, SAFETY OR OTHER PARTS OF THE FIRING MECHANISM OF THIS OR ANY OTHER FIREARM. FAILURE TO OBEY THIS WARNING MAY RESULT IN INJURY OR DEATH TO YOURSELF OR OTHERS.

BE CAREFUL!

WINCHESTER®
RIFLES AND SHOTGUNS

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